Dote: User:

Tuesday, 29/07/2008 4:56:34 PM

Julie Lecocq

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

: 40789

Job Number Estimate Number

: 13513

P.O. Number

This Issue

: 29/07/2008

: NC Prsht Rev. : 11

First Issue **Previous Run**

Type

S.O. No. :

Part Number

Drawing Name

: D21981

Drawing Number

: D2198 REV C

: BRACKET

Project Number

: N/A : C

Drawing Revision

Material **Due Date**

: 08/08/2008

Qty:

10 Um:

Each

Written By Checked & Approved By

Comment

: Est Rev:A

08-07-24 new issue ec verified by:dd

: SMALL /MED FAB

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0 M304S16GA



Comment: Qty.: 0.1313 sf(s)/Unit

Total: 1.3125 sf(s)

304 SS Sheet 0.063" thick

batch: <u>(587) 4</u>

2.0

FLOW WATER JET

304/316 Sheet .063



Comment: FLOW WATER JET

1-Cut as per Dwg D2198

Dwg Rev:________________________ Prog Rev:_

2-Deburr if necessary



3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



8-6-6



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

Comment: SECOND

BRAKE NC 5.0

NC BRAKE

SECOND CHECK



Comment: NC BRAKE

Bend as per dwg D2198

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES															
DATE	STEP	PROCEDURE CHANGE		PROCEDURE CHANGE By D		PROCEDURE CHANGE By Date Q		PROCEDURE CHANGE By Date Qty Chie		P PROCEDURE CHANGE		PROCEDURE CHANGE By Date Qt				Approval Chief Eng / Prod Mgr	Approval QC Inspector
						;											

Part No:	PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:	· · · · · · · · · · · · · · · · · · ·
			QA: N/C	Closed:	Date:	

NCR:			ER NON-CONFORMANC	E (NCR)		İ		
		Description of NC		Corrective Action Section B			Approval	A
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Tuesday, 29/07/2008 4:56:34 PM Date: User: Julie Lecocq **Process Sheet** Drawing Name: BRACKET Customer: CU-DAR001 Dart Helicopters Services Job Number: 40789 Part Number: D21981 Job Number: Seq. #: **Machine Or Operation:** Description: INSPECT WORK TO CURRENT STEP QC5 6.0 Comment: INSPECT WORK TO CURRENT STEP PACKAGING 1 PACKAGING RESOURCE #1 7.0 Identify wiith Part part # using a fine point permanent marker and Stock Location: QC21 FINAL INSPECTION/W/O RELEASE 8.0 1 08/08/269 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No	•	PAR #: Fault Category:	NCR: Yes	No DQ	A :	_ Date:			
			QA:	N/C Close	d:	Date:			

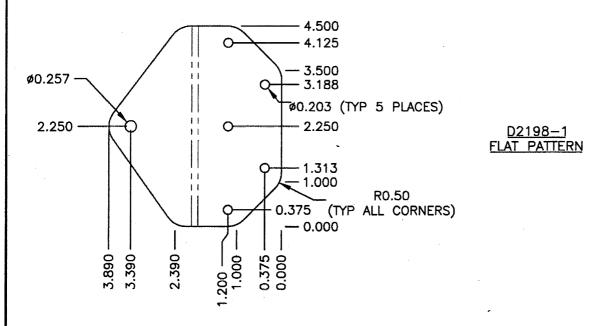
NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
DATE		Description of NC		Corrective Action Section B		Varification	A =======	A			
	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspecto			
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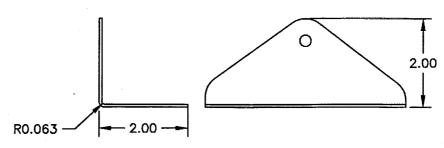
NOTE: Date & initial all entries





\	DESIG	*#	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
/	CHEC	(ED/	APPROVED	DRAWING NO.	REV. (c
		Ш	de	D2198 SHEET	1 OF	1
	DATE		,	TITLE	SCALI	Ē
	03.0	5.28		BRACKET	1::	2
_	В		93.10.05	REDESIGN		
	С		03.05.28	REDRAW		





D2198-1 BRACKET BEND DETAIL

D2198-1 MATERIAL: AISI 304/316 S.S. 0.064" THICK (M304S16GA)

FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

BREAK ALL SHARP EDGES 0,005 TO 0.015

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

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Confederation of the Action of

-DART-AEROSPACE LTD	Work Order:	40789
Description: BRACKET	Part Number:	D3148-1
Inspection Dwg: 1)2198-1 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Q ,303	1005-001	F061	×			
	100 000.+	1362	×			
,357	4- ,010	(357	X9			
1.313	7010	1,315	×			
2.750	4010	3.355	20			
3.188	t/ao	3 195	X			
4.125	4010	4.176) Jes			·
4.500	1/010	4.496	A			
,375	7010	371)e			
1.300	.010	1.204	<u>ک</u>		_	· ·
3.396	4010	3,391	d			
3.890	th -010	3.892	×			
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Measured by:	B	Audited by:	5, ,	Prototype Approval:	A	
Date:	8-8-6	Date:	20000	Date:		7

Rev	Date	Change	Revised by	Approved
Α		New Issue	KJ/JLM	

